



Dart Aerospace Ltd.
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647.0112
Job Sheet 181418



Part No: 647.0112

Job Qty: 60 ea

Part Name: Strut Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/26/18

Job Tracking No:

Due Date: 9/10/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG 647.0100 REV.B SHEET 3 IPP REV:A 12.08.14 NEW ISSUE DD VERF:JFS IPP REV:B 18.02.08 AS
PER DWG REV.B DD VERF:JFS

Ship Via:

647.0112
REV.B

5097197

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	60 Ea	9/10/18	9/10/18	0.00	0.00	Start Up Waterjet		18/07/28
100	Waterjet	60 pcs	9/10/18	9/10/18	0.00	2.36	Waterjet1		18/07/28
110	QC	60 pcs	9/10/18	9/10/18	0.00	0.00	QC2 Waterjet-1		18/07/28
120	QC	60 pcs	9/10/18	9/10/18	0.00	0.00	QC8-1		38
130	Brake NC	60 pcs	9/10/18	9/10/18	0.00	2.68	Brake NC 1		9-89
140	QC	60 pcs	9/10/18	9/10/18	0.00	0.00	QC5		15-08-01
150	SprayPaint	60 pcs	9/10/18	9/10/18	0.00	1.40	Spray Paint		15-08-01
160	QC	60 pcs	9/10/18	9/10/18	0.00	0.00	QC14		15-08-01
170	Packaging	60 pcs	9/10/18	9/10/18	0.00	0.00	Packaging3-1		15-08-01
180	QC21-SA	60 Ea	9/10/18	9/10/18	0.00	0.00	QC21		15-08-01

Part Op 100 - 1-Cut as per Dwg Dwg Rev: B Prog Rev: B 2-Deburr if necessary
Descriptions: 130 - USE DT9834 FOR FORMING

150 - PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N PRIME AS PER DWG NOTE 6 BATCH: 5094268

170 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S14GA	304SS sheet .080	1.9500 sf (.0325 ea)	90-Start up Operation	5080377

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S14GA	2	109	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Strut Bracket	0.177Inches + 0.005 - 0.001	0.182 0.176		
2	Strut Bracket	0.191Inches + 0.005 - 0.001	0.196 0.190		
3	Strut Bracket	0.300Inches ± 0.030	0.330 0.270		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Not Approved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		QTY Effective : _____		MRB (QSI042) Approval			
Description W		DART Aerospace Ltd. 1270 Aberdeen Street Cambridge, ON K4A 1K7 TEL: 1 813 632-8200 Email: sales@dartaero.com www.dartaerospace.com Date: 07/28/18					
						Completed By	
						Lead hand / Supervisor Approval Verification	
		QC / QA Coordinator Approval					
Root Cause							
Environment	☐	No R	☐				
Design	☐	Open	☐				
Doc/Data	☐	Offset/Setup	☐				
Equip/Tooling	☐	Supplier	☐	Cracks			
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave			
Material	☐	Use for Testing	☐	Cuffs			
Internal Transport	☐	Poor Information	☐	Crushing			
Tribal Knowledge	☐	Rushing	☐	Heat Treat			
LOA	☐	Product Improvement	☐	Wave/Twist in Tube			
Substation	☐	Process Improvement	☐	Marks/Chatter			
Past Expiry Date	☐	Manufacturing Process	☐				
Misidentified	☐	Past Due	☐	OTHER :			

4	Strut Bracket	0.900Inches $\pm$ 0.030	0.930 0.870
5	Strut Bracket	0.350Inches $\pm$ 0.010	0.360 0.340
6	Strut Bracket	1.500Inches $\pm$ 0.030	1.530 1.470
7	Strut Bracket	1.006Inches $\pm$ 0.030	1.036 0.976
8	Strut Bracket	0.080Inches $\pm$ 0.010	0.090 0.070

Plex 7/26/18 8:32 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐				